



Dart Aerospace Ltd.
1270 Aberdeen St
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K6A 1K7
Canada

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D5634-041BENT
Job Sheet 200850



Part No: D5634-041BENT

Job Qty: ~3 pcs

Part Name: Float Skidtube Assembly, Bent



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/18/19

Job Tracking No:

Due Date: 10/4/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG D5634 REV.A IPP REV:A 19.01.17 NEW ISSUE DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Skidtubes - Bend - 1	3 pcs		10/4/19	0.50	1.00	Skidtubes - Bend		MGL
120	QC 5	3 pcs		10/4/19	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		BE
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61		
							QC 5 - 81		
130	Packaging 3-1 - Stock - B4B	3 pcs		10/4/19	0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		
							Packaging 3 - 7 - B4B		
							Packaging 3 - 8 - B4B		
							Packaging 3 - 9 - B4B		
							Packaging 3 - 10 - B4B		
							Packaging 3 - 11 - B4B		



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CANADA
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Container No: S216982



Part: D5634 - 041BENT

Job No: 200850

Serial No/Batch: S216982

Revision: A

Inspector:

Exp Date:

Instructions:

Date: 09/25/19

Plex 9/18/19 11:19 AM Dart.lajeunesse.marie

				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	DE
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				QC 21 - SA - 21	DAB 21 SEP 26 2019
				QC 21 - SA - 70	21
140 QC 21 - SA	3 pcs	10/4/19	0.00 0.00		

Part Op 110 - ****VERIFY AND INSPECT THE MATERIAL PRIOR TO USE**** 1- Bend FWD end of tube using bend prog D5634
 Descriptions: FWD and FOLIO 35 as per dwg D5634, cut fwd end of tube with saw table setup D5634 .

120 - (QC5- Inspect part completeness to step on W/O)

130 - (Identify as per dwg & Stock Location: LG002) LOCATION : LG002

140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2600-1-190	Extrusion Round 3" 206	3 pcs (1 ea)	110-Skidtubes - Bend - 1	S/13022

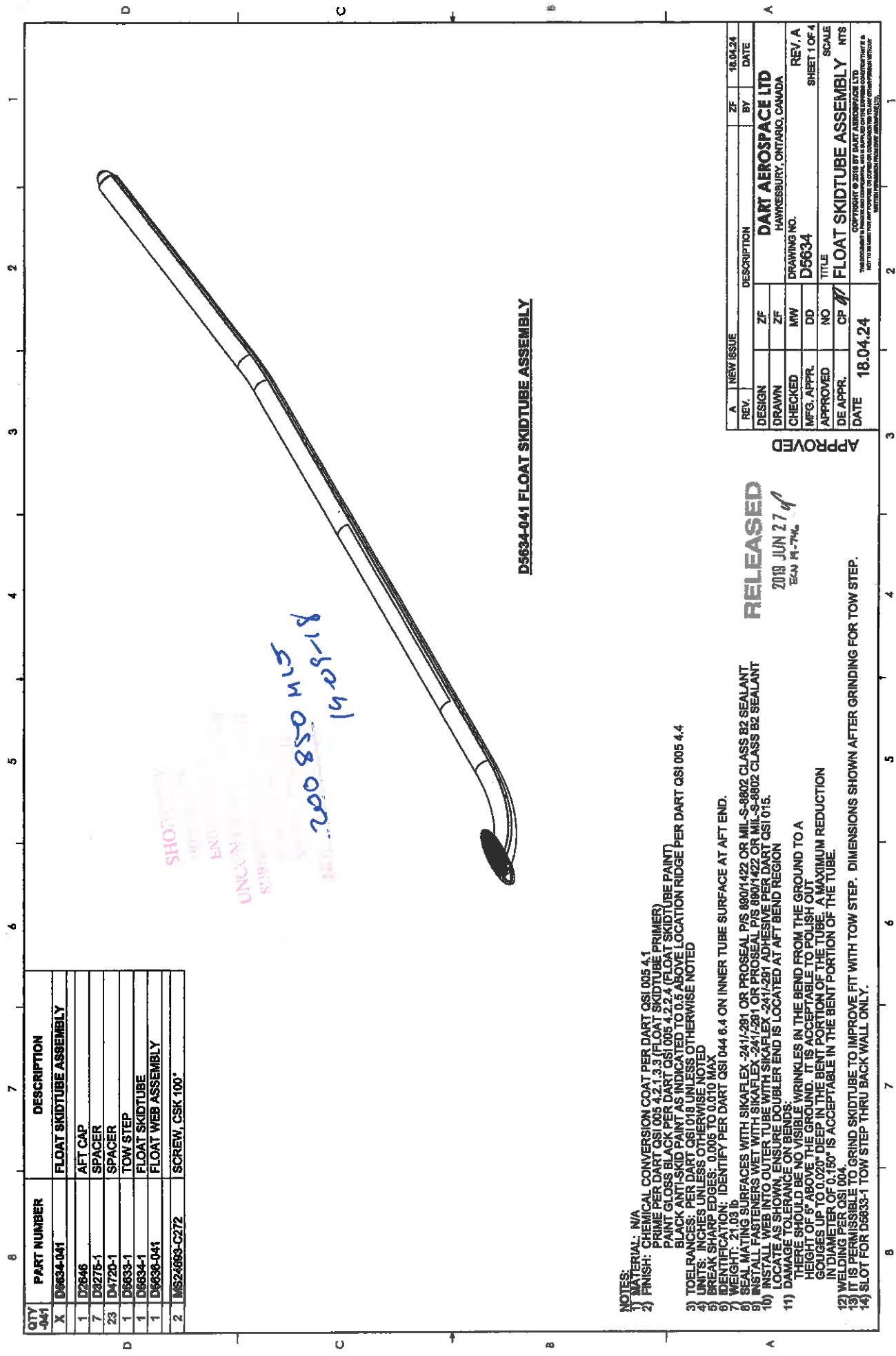
Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Skidtubes - Bend - 1	D2600-1-190	3	22	0

Part Specifications

Specifications could not be found.

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D5634-041 FLOAT SKIDTUBE ASSEMBLY

QTY	PART NUMBER	DESCRIPTION
X	D5634-041	FLOAT SKIDTUBE ASSEMBLY
1	D2646	AFT CAP
7	D8275-1	SPACER
23	D4720-1	SPACER
1	D6833-1	TOW STEP
1	D6834-1	FLOAT SKIDTUBE
1	D6836-041	FLOAT WEB ASSEMBLY
2	M824869-C272	SCREW, CSK 100°

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME PER DART QSI 005 4.2, 1.3 (FLOAT SKIDTUBE PRIMER)
PAINT GLOSS BLACK PER DART QSI 005 4.2, 2.4 (FLOAT SKIDTUBE PAINT)
BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.006 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 & 4 ON INNER TUBE SURFACE AT AFT END.
 - 7) WEIGHT: 21.03 lb
 - 8) SEAL MATING SURFACES WITH SIKAFLEX -241/-281 OR PROSEAL P/S 880/1422 OR MIL-S-8802 CLASS B2 SEALANT
 - 9) INSTALL FASTENERS WET WITH SIKAFLEX -241/-281 OR PROSEAL P/S 880/1422 OR MIL-S-8802 CLASS B2 SEALANT
 - 10) INSTALL WEB INTO OUTER TUBE WITH SIKAFLEX -241/-281 ADHESIVE PER DART QSI 015.
 - 11) DAMAGE AS SHOWN, ENSURE DOUBLER END IS LOCATED AT AFT BEND REGION
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5" ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020" DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
 - 12) WELDING PER QSI 004.
 - 13) IT IS PERMISSIBLE TO GRIND SKIDTUBE TO IMPROVE FIT WITH TOW STEP. DIMENSIONS SHOWN AFTER GRINDING FOR TOW STEP.
 - 14) SLOT FOR D5633-1 TOW STEP THRU BACK WALL ONLY.

RELEASED

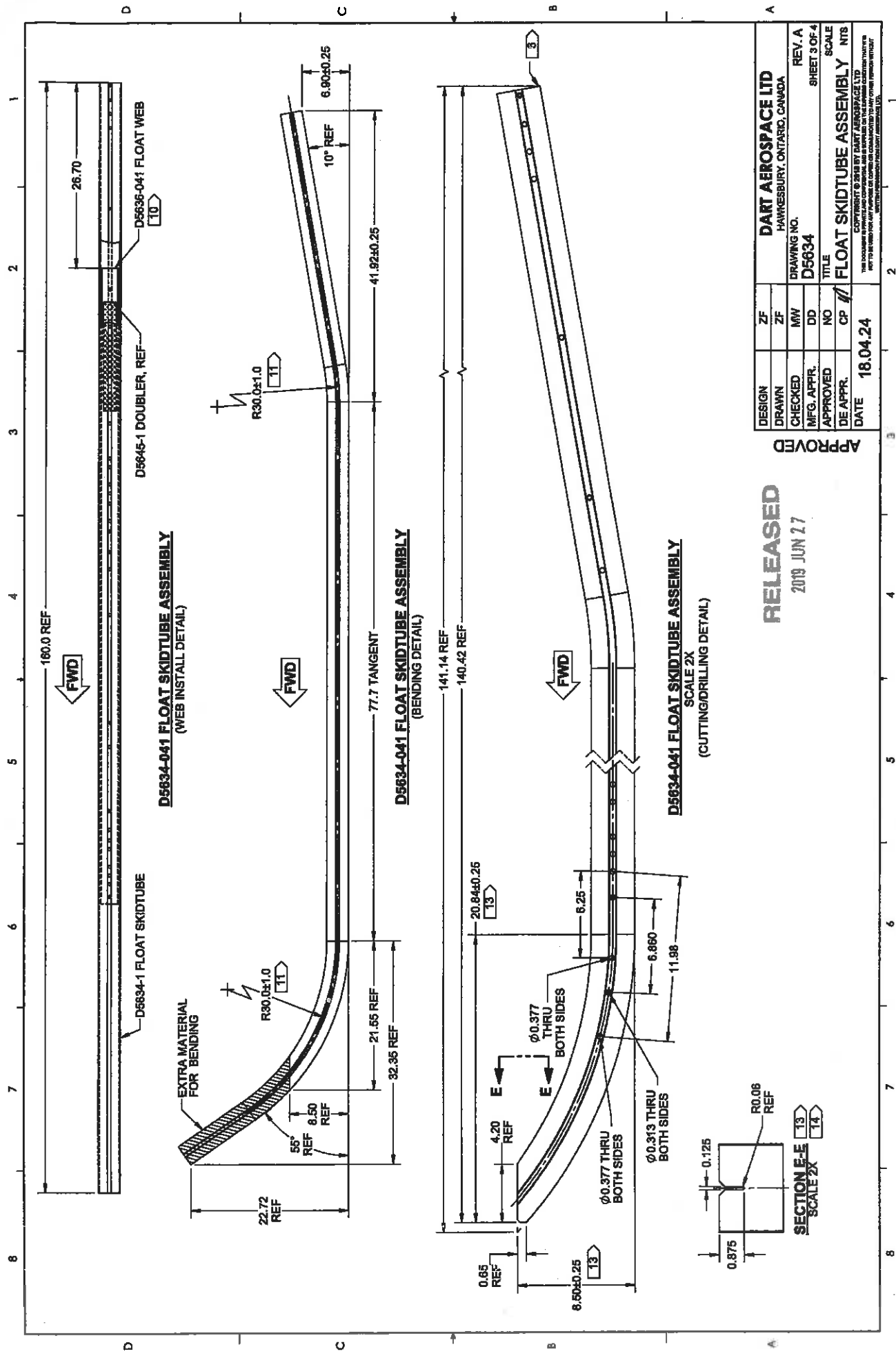
2018 JUN 27
EQU M-746

APPROVED

REV.	NEW ISSUE	DESCRIPTION	ZF	BY	DATE
DESIGN					
DRAWN					
CHECKED					
INFG. APPR.					
APPROVED					
DE APPR.					
DATE	18.04.24				

DART AEROSPACE LTD		REV. A
HAWKESBURY, ONTARIO, CANADA		
DRAWING NO.	D5634	SHEET 1 OF 4
TITLE	FLOAT SKIDTUBE ASSEMBLY	SCALE
DATE	18.04.24	NTS

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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐



Job: _____ Part No. _____		DISPOSITION Rework ☐ ☐ Scrap ☐ ☐ Use-as-is ☐ ☐				DEPARTMENT/PROCESS Skid-tube ☐ ☐ ☐ ☐ ☐ Machining ☐ ☐ ☐ ☐ ☐ Large Fab ☐ ☐ ☐ ☐ ☐ Cross tube ☐ ☐ ☐ ☐ ☐ Small Fab ☐ ☐ ☐ ☐ ☐ Finishing ☐ ☐ ☐ ☐ ☐ Eng. (Non-AW) ☐ ☐ ☐ ☐ ☐ Prod. Eng. Coord. ☐ ☐ ☐ ☐ ☐ Rec/Store/Packaging ☐ ☐ ☐ ☐ ☐ Engineering ☐ ☐ ☐ ☐ ☐ Water Jet ☐ ☐ ☐ ☐ ☐ Supplier ☐ ☐ ☐ ☐ ☐ Quality ☐ ☐ ☐ ☐ ☐				Date: _____ Sequence #: _____		QTY Affected: _____		MRB (QSI042) _____																																																																					
Description Work Order Deviation						Disposition																																																																													
Root Cause <table border="1"> <tr> <td>Operator</td><td>☐</td> </tr> <tr> <td>Manufacturing Process</td><td>☐</td> </tr> <tr> <td>Equip/Tooling</td><td>☐</td> </tr> <tr> <td>Handling/Preservation</td><td>☐</td> </tr> <tr> <td>Material</td><td>☐</td> </tr> <tr> <td>Product Improvement</td><td>☐</td> </tr> <tr> <td>Process Improvement</td><td>☐</td> </tr> <tr> <td>Human Factors</td><td>☐</td> </tr> </table>						Operator	☐	Manufacturing Process	☐	Equip/Tooling	☐	Handling/Preservation	☐	Material	☐	Product Improvement	☐	Process Improvement	☐	Human Factors	☐	FAULT CATEGORY <table border="1"> <tr> <td>Pressure/Forced</td><td>☐</td> <td>Contamination</td><td>☐</td> <td>Power Loss/Surge</td><td>☐</td> <td>Positioned Wrong</td><td>☐</td> </tr> <tr> <td>Bending</td><td>☐</td> <td>Misaligned/off center</td><td>☐</td> <td>Folio/Program</td><td>☐</td> <td>Outside Tolerance</td><td>☐</td> </tr> <tr> <td>Crushing</td><td>☐</td> <td>BOM/Route</td><td>☐</td> <td>Grain Direction</td><td>☐</td> <td>Drawing</td><td>☐</td> </tr> <tr> <td>Cracks</td><td>☐</td> <td>Broken/Damage/Defect</td><td>☐</td> <td>Weld</td><td>☐</td> <td>Finish</td><td>☐</td> </tr> <tr> <td>Crimp/Kink/Ripple/Wave/Twist</td><td>☐</td> <td>Incomplete/Unclear Instructions</td><td>☐</td> <td>Wrong Stock Pulled</td><td>☐</td> <td>Part Lost/Missing</td><td>☐</td> </tr> <tr> <td>Marks/Chatter</td><td>☐</td> <td>Drill Holes</td><td>☐</td> <td>Out of Sequence</td><td>☐</td> <td>Misread</td><td>☐</td> </tr> <tr> <td>Mislabeled</td><td>☐</td> <td>Fit/Function</td><td>☐</td> <td>Off-set/Set-up</td><td>☐</td> <td></td><td></td> </tr> </table>						Pressure/Forced	☐	Contamination	☐	Power Loss/Surge	☐	Positioned Wrong	☐	Bending	☐	Misaligned/off center	☐	Folio/Program	☐	Outside Tolerance	☐	Crushing	☐	BOM/Route	☐	Grain Direction	☐	Drawing	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Finish	☐	Crimp/Kink/Ripple/Wave/Twist	☐	Incomplete/Unclear Instructions	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐	Marks/Chatter	☐	Drill Holes	☐	Out of Sequence	☐	Misread	☐	Mislabeled	☐	Fit/Function	☐	Off-set/Set-up	☐		
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